

# Work Order ID 65298



Page 1

January 11, 2011 9:19:18 AM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 1/21/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-01-11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

*Sul 2/24*

*MF 11-02-18*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M108436*  
*M115928*

3-Grind End Plate flush

*11.02.10*

*10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65298



Page 2

January 11, 2011 9:19:25 AM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 1/21/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				(x 10)		08E11/02/10	
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(x 10) RH			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00						10	

*Handwritten notes:* 8/11/02/10, 10, and a signature.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Start Date: 1/21/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272  
A/R ☐ Aluminum Rod ☒ M102436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

= m L 11/02/11 (10X)

11.02.11

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 5

January 11, 2011 9:19:31 AM

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Start Date: 1/21/11 Start Qty: 10.00

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Required Date: 2/18/11 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	<i>115591</i>					<i>X10RH</i>	<i>6</i>	<i>90</i>	<i>11/01/11</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>12:00pm</i>								
	OVEN TEMPERATURE: <i>326°F</i>								
	FINISH TIME: <i>12:30pm</i>								
230	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
	<i>11116463</i>					<i>X10RH</i>	<i>6</i>	<i>90</i>	<i>11/01/11</i>
HandFinish	Memo	0.00							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

*11/2/22* *(100)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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January 11, 2011 9:19:36 AM



Page 6

Item ID: D350-591-312

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Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: <u>11/11</u>								

11/2/22 SP

8/10/22/24

11/10  
RH

2003

1/2/20 10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 65298**

Page 7

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Revision ID:

Stop



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Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/24

MF  
11-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January 11, 2011 9:19:14 AM

Page 1

Work Order ID: 65298

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH



Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:c IPP Rev:D  
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D3272-1 Step		Manufactured	No			110	Each	20.0000	1	10			
-------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
WA <u>B65299</u>	20	<u>10</u>
64910	10	
64911	10	

✓ D3067-1 End Plate		Manufactured	No			110	Each	116.0000	1	10			
------------------------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
WA	116	
60141	2	
62664	6	
<u>63550</u>	108	<u>10</u>

✓ D3219-1 Plate		Manufactured	No			110	Each	113.0000	2	20			
--------------------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
WA	113	
<u>63551</u>	113	<u>20</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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January 11, 2011 9:19:14 AM

Work Order ID: 65298

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

✓ D3066-1

Manufactured No

180

Each

86.0000

2

20



Spacer



*11.02.15*

Location

Loc Qty

Loc Code

WA

*365072*

86

*20*

63549

86

✓ MS20600-AD4W4

Purchased

No

180

Each

2,351.000

16

160



Rivets



*11.02.15*

Location

Loc Qty

Loc Code

ST321

*3116712*

2351

*160*

113368

38

114181

11

114718

2

115573

147

115640

31

116022

622

116188

1500

✓ D3065-041

Manufactured

No

180

Each

42.0000

1

10



Step Leg Assembly Hi



*11.02.15*

Location

Loc Qty

Loc Code

WA

*363554*

42

*10*

63324

2

63555

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 65298

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

✓ D3067-1. Manufactured No 180 Each 116.0000 1 10  
  
 End Plate

Location	Loc Qty	Loc Code
WA 365969	116	10
60141	2	
62664	6	
63550	108	

S AN3-35A Purchased No 250 Each 168.0000 2 20  
  
 Bolt

Location	Loc Qty	Loc Code
ST353	168	
116191	100	
116419	18	
116549	50	

S D3235-1, Manufactured No 250 Each 61.0000 2 20  
  
 Mounting Lug

Location	Loc Qty	Loc Code
ST471	61	
61845	1	
63547	60	

S D3278-041 Manufactured No 250 Each 8.0000 1 10  
  
 Support Assembly

Location	Loc Qty	Loc Code
ST460	8	
64731	8	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

January 11, 2011 9:19:15 AM

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

30.0000

16

160



Washer



1116304 11/2/22

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

AN960JD516 NAS1149D0563J Purchased

No

250

Each

34.0000

4

40



Washer



1116540 11/2/22

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN5-36A Purchased

No

250

Each

151.0000

2

20



Bolt



11/2/22

Location

Loc Qty

Loc Code

ST341

151

114292

1

116191

100

116549

50

D2618 Manufactured

No

250

Each

36.0000

2

20



Bushing



865071 11/2/22

Location

Loc Qty

Loc Code

ST019

36

63548

36

January 11, 2011 9:19:15 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 65298

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No

250

Each

94.0000

4

40



Lug

Location

Loc Qty

Loc Code

ST476

94

55452

2

63312

12

64422

80



B65067 11/2/22 SP  
B66126 \* (38) SP

D2856-400

Manufactured No

250

f

272.5810

1.2

12



Abraison Strip

Location

Loc Qty

Loc Code

ST403

272.5810421

56626

0.00004211

59920

56.581

63735

216



11/2/22 SP

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250

Each

3,274.000

2

20



Nut

Location

Loc Qty

Loc Code

ST300

3274

114784

9

115835

765

116391

900

116540

800

116549

800



11/2/22 SP 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 6

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

185.0000

8

80



Bolt



11/16/669 11/2/22sf

## Location

## Loc Qty

## Loc Code

ST357

185

116191

185

MS21042L5

Purchased

No

250

Each

1,357.000

2

20



Nut



11/2/22sf

## Location

## Loc Qty

## Loc Code

ST139

26

114813

26

ST300

1331

115156

5

115594

500

116104

130

116105

496

116548

200

MS21042L4

Purchased

No

250

Each

4,846.000

8

80



Nut



11/2/22sf 10x

## Location

## Loc Qty

## Loc Code

ST300

4846

1123143

2

115589

10

115621

334

116188

3500

116548

1000

January 11, 2011 9:19:16 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
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Page 7

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Start Date: 1/21/11

Required Date: 2/18/11

Start Qty: 10.00

Required Qty: 10.00

AN960JD10 NAS1149D0363J Purchased

No

250

Each

8.0000

4

40



Washer



M116007 1/12/22 102 SP

S  
PID

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>92</i>	DRAWN BY <i>13</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**07.06.04-*ff***REFERENCE ONLY**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

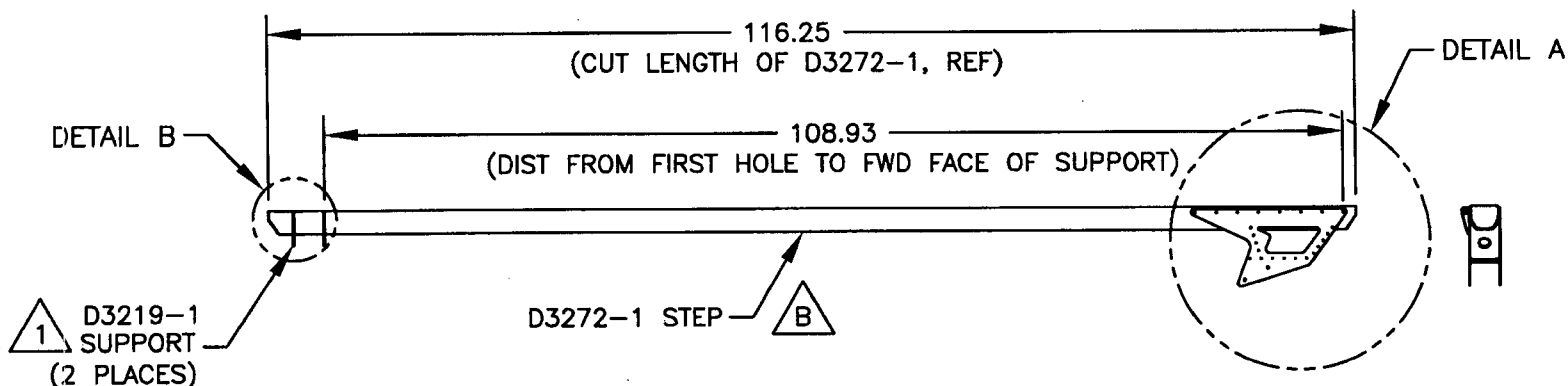
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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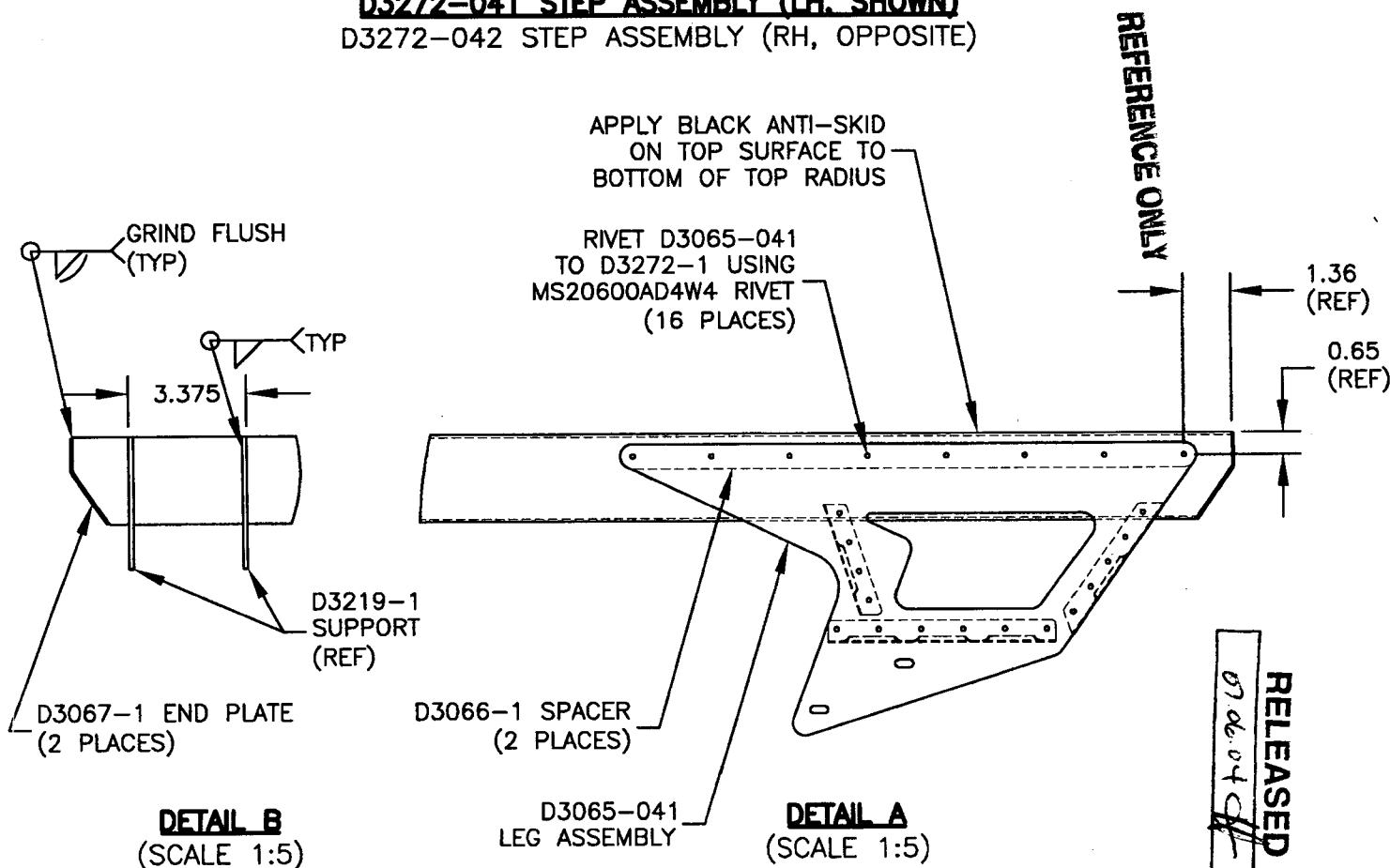
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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 3
DATE	TITLE	SCALE	
07.05.18	STEP ASSEMBLY, HI LONG	1:20	



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**

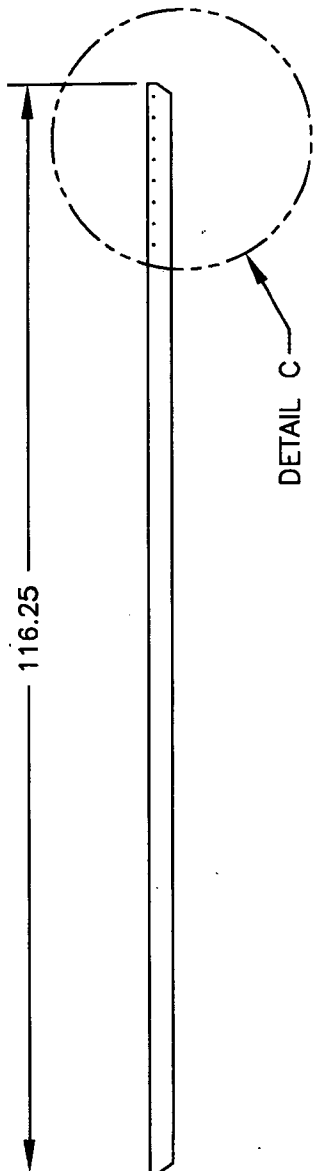




DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

07.06.04 *[Signature]*

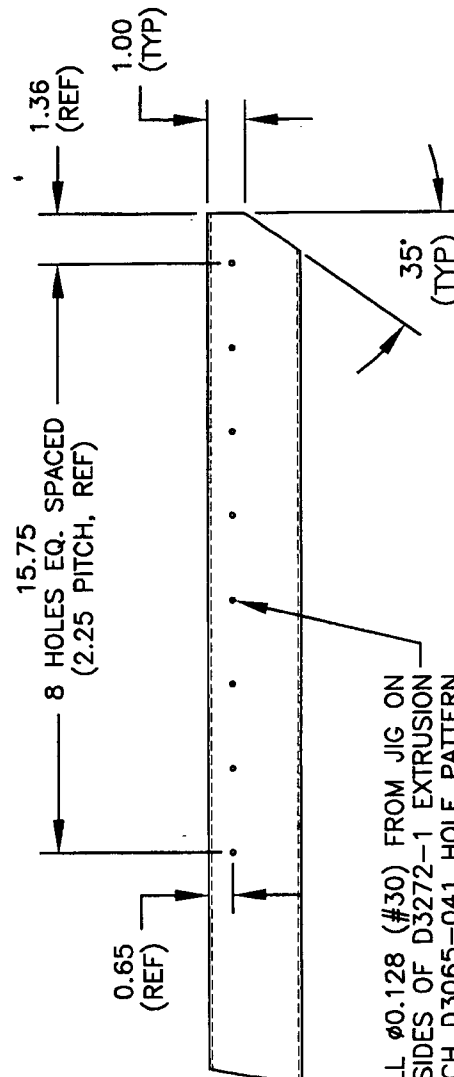


DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)

REFERENCE ONLY



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X							11	D350-591-211	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
	X						11	D350-591-212	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
		X					11	D350-591-213	<b>Heli-Access-Step™</b> , Short Step – High Skid, LH
			X				11	D350-591-214	<b>Heli-Access-Step™</b> , Short Step – High Skid, RH
				X			11	D350-591-215	<b>Heli-Access-Step™</b> , Short Step – Low Skid, LH
					X		11	D350-591-216	<b>Heli-Access-Step™</b> , Short Step – Low Skid, RH
						X		D350-591-311	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
							X	D350-591-312	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: **G**  
Date: 08.10.06